

Date: Friday, 6/1/2007 1:02:27 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	32737		
Estimate Number	12736		
P.O. Number	N/A	Part Number	D353515
This Issue	6/1/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3535 UNDER REVIEW
First Issue	N/A	Project Number	N/A
Previous Run	31990	Drawing Revision	A/B
Written By		Material	N/A
Checked & Approved By		Due Date	6/8/2007
Comment	Est Rev:A New Issue 07-02-15 JLM	Qty:	20
Unit:	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
		Comment: Qty.: 1.0715 sf(s)/Unit Total : 21.4305 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: M104640	ml 01 06 08 (20)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B	ml 01 06 08 (20)
		2-Deburr if necessary	MF 07-06-19 (20)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	ml 01 06 08 (20)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	Sn 07/06/18 X70 (20)
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15	MF 07-06-20 (20) SB 07/06/21 (20)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/06/26  
 QA: N/G  Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32737

Part Number: D353515

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*J* *1 En 07/06/21* *120* *Cont'd*

7.0 POWDER COATING

POWDER COATING



*M101601*



*QOX*

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*m-f* *07/06/22*

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Fk* *07/06/25* *60*

9.0 PACKAGING 1

PACKAGING RESOURCE #1



*QOX*

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *EP-15*

*m-f* *07/06/25*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



*20*

Comment: FINAL INSPECTION/W/O RELEASE

*m-f 07/06/26*

Job Completion



*U 07/06/26*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32737
Description: Wearshoe	Part Number:	D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.893	✓		vern	
2.000	+/-0.010	2.000	✓		M-T	
5.650	+/-0.010	5.650	✓		M-T	
9.150	+/-0.010	9.150	✓		M-T	
14.400	+/-0.010	14.400	✓		M-T	
19.650	+/-0.010	19.650	✓		M-T	
24.900	+/-0.010	24.900	✓		M-T	
30.150	+/-0.010	30.150	✓		M-T	
33.650	+/-0.010	33.650	✓		M-T	
35.650	+/-0.010	35.650	✓		M-T	
39.150	+/-0.010	39.150	✓		M-T	
Ø0.188	+0.005/-0.001	0.190	✓		vern	
24.00	+/-0.030	24.00	✓		M-T	
16.00	+/-0.030	16.00	✓		M-T	
8.00	+/-0.030	8.00	✓		M-T	
5.00	+/-0.030	5.00	✓		M-T	
0.300	+/-0.010	0.297	✓		vern	
0.300	+/-0.010	0.300	✓		vern	
0.038	+/-0.010	0.037	✓		vern	

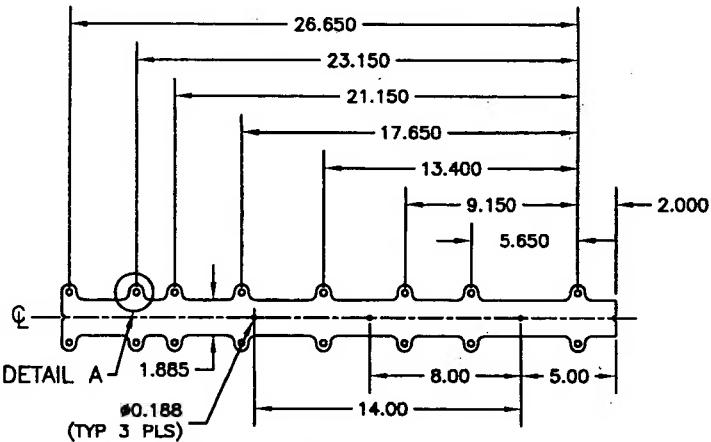
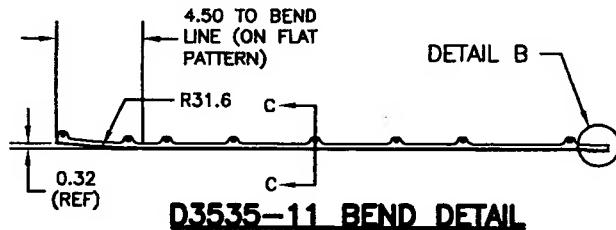
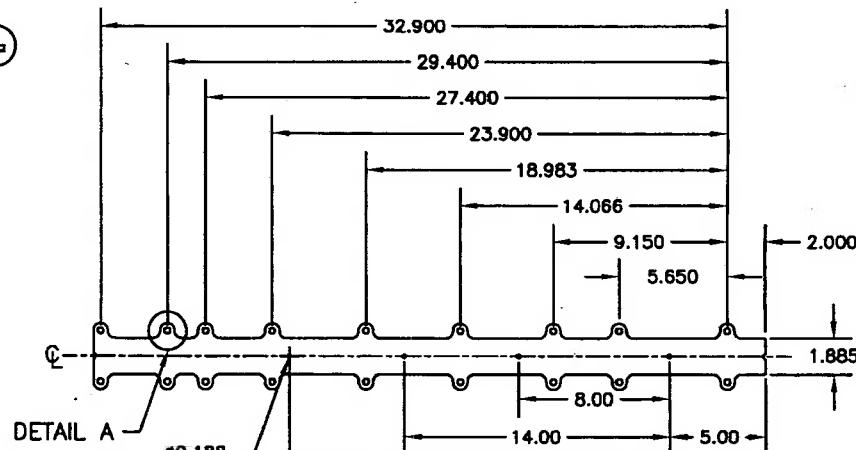
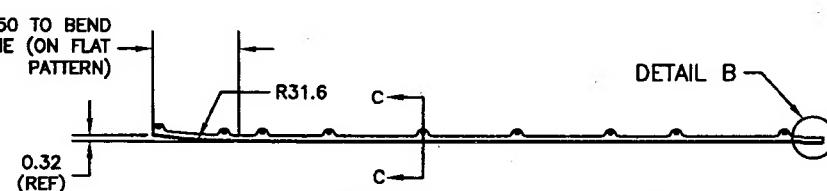
Measured by:	M. M	Audited by:	S	Prototype Approval:	N/A
Date:	07 06 08	Date:	07/06/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
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DATE		DRAWING NO.
CB	MH	D3535
07.04.17		TITLE
A	06.10.25	WEARSHOE
B	07.04.17	NEW ISSUE
		MOVE TAB OUTBOARD, ADD AMS SPEC

RELEASED  
27.04.24

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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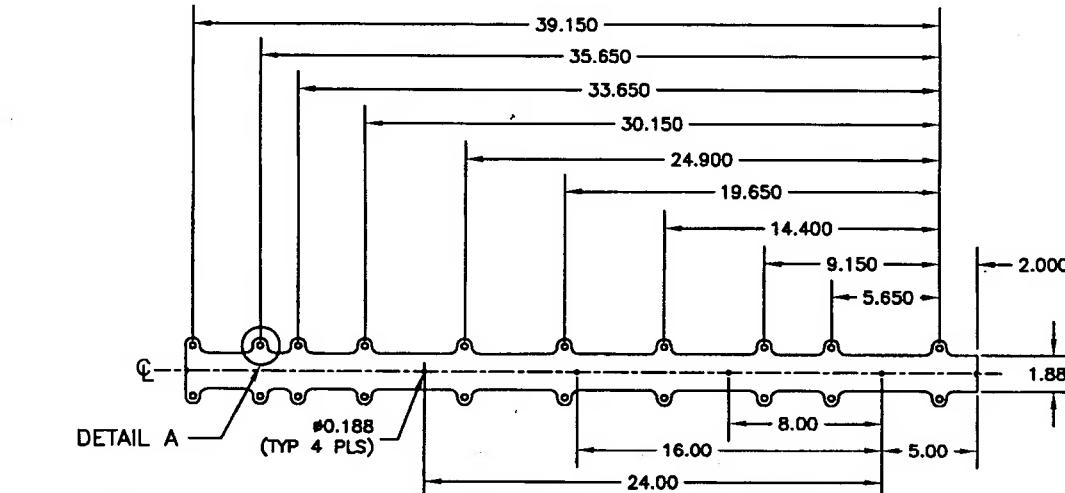
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**NOTES**

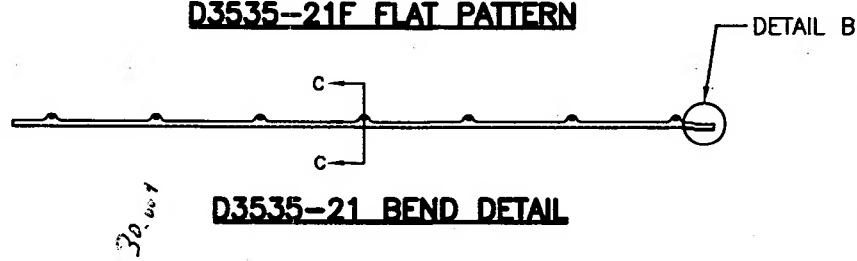
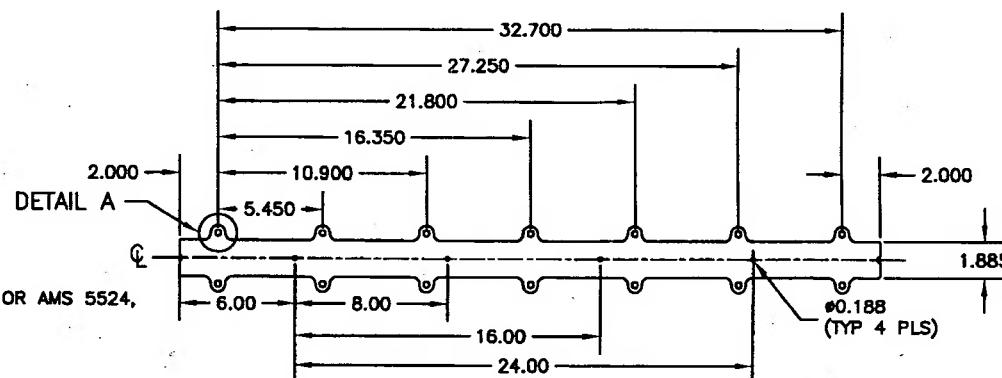
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20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
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**D3535-15 BEND DETAIL**



**NOTES**

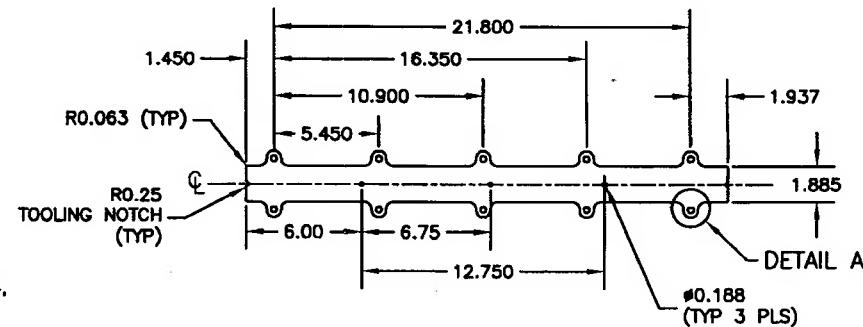
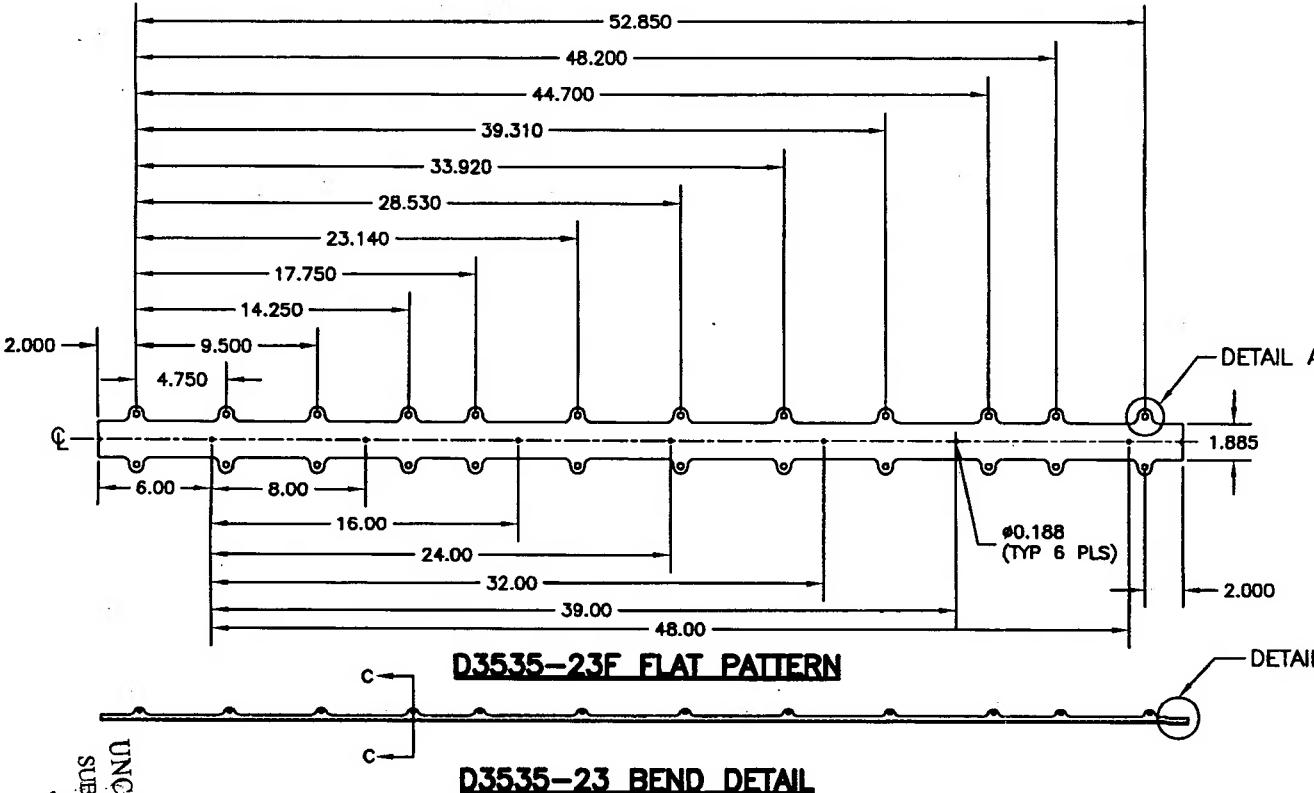
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
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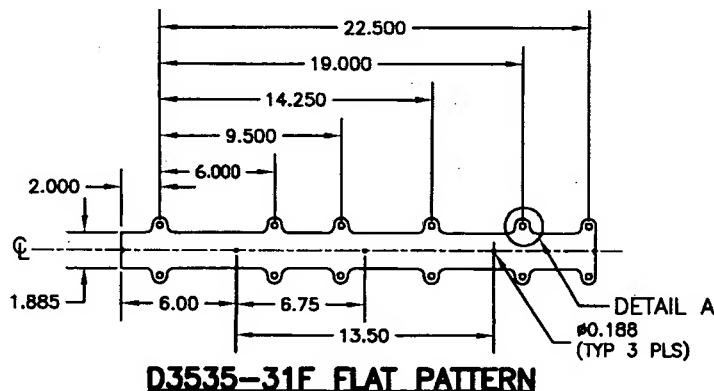
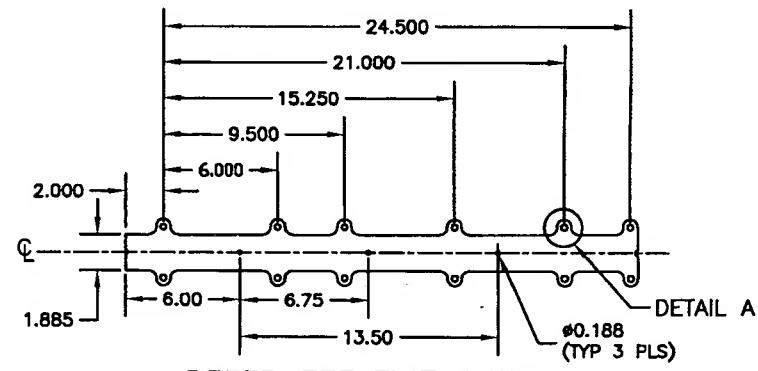
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07.04.24**D3535-25 BEND DETAIL****NOTES**

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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
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07.04.17**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

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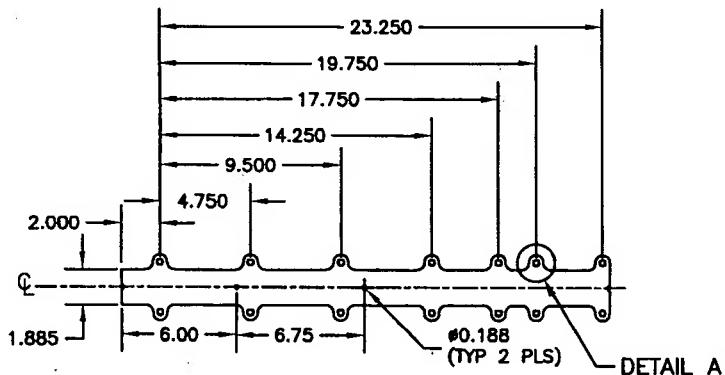
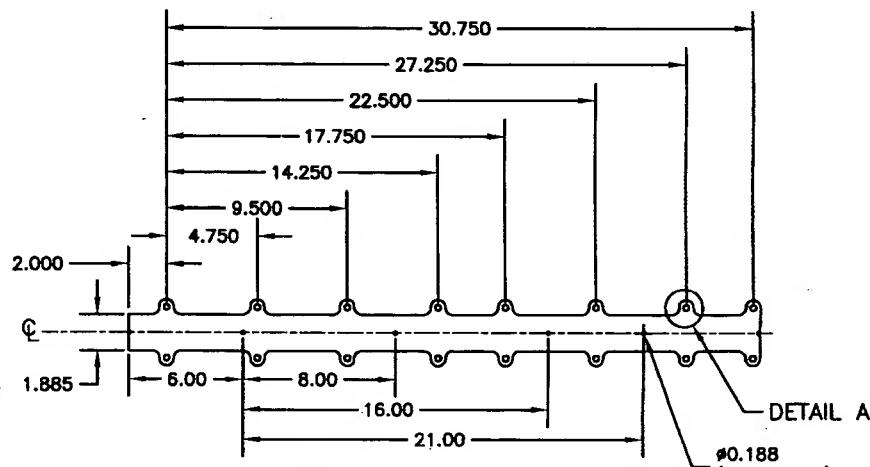
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
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(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
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07.04.24**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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		SCALE 1:10

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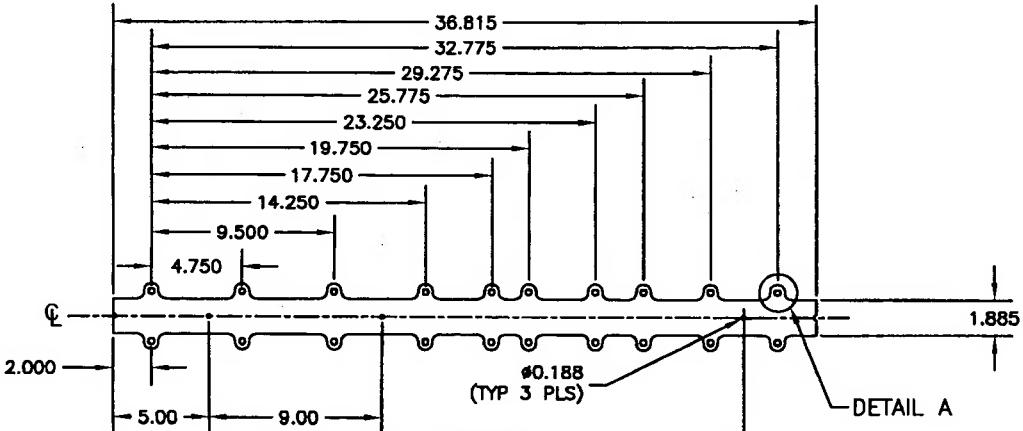
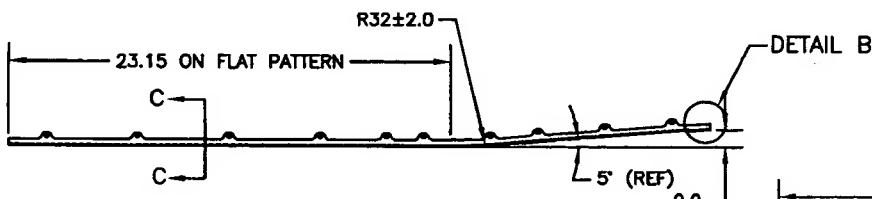
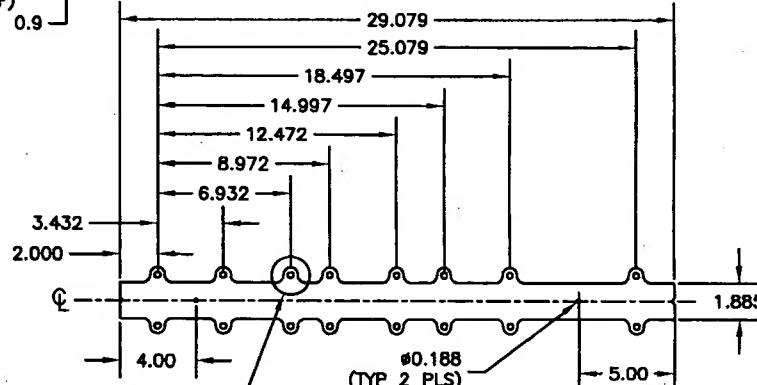
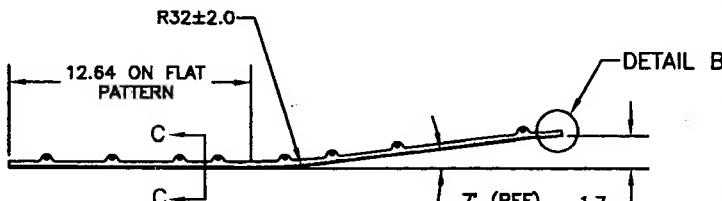
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DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SHEET 6 OF 7

REV. B  
SCALE 1:10

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07.04.24**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

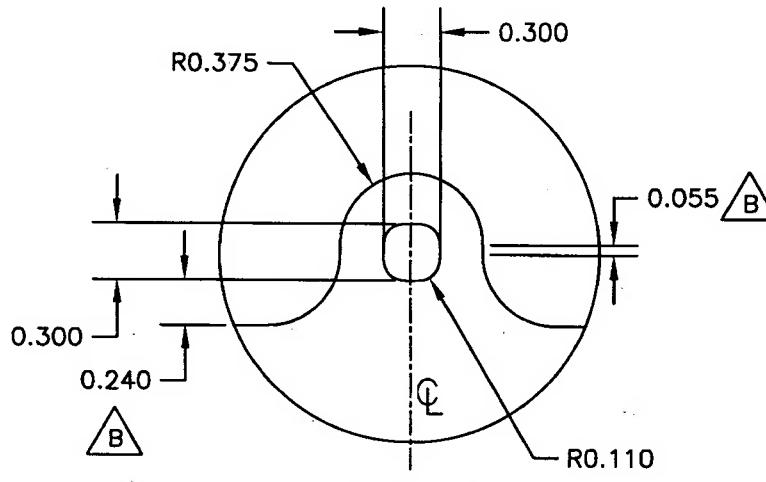
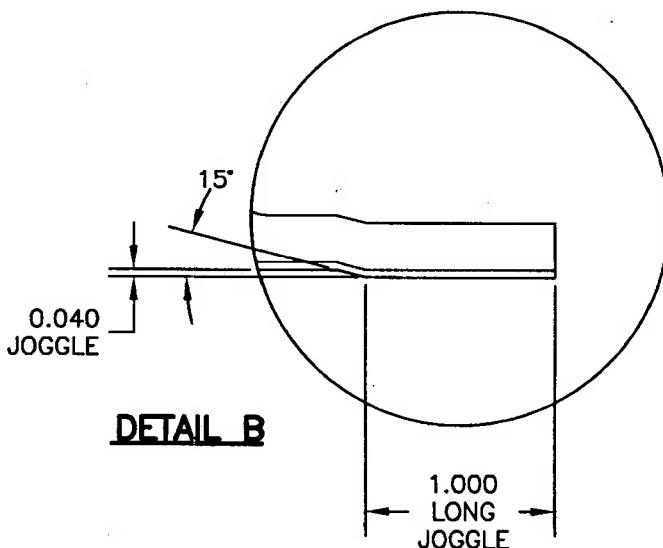
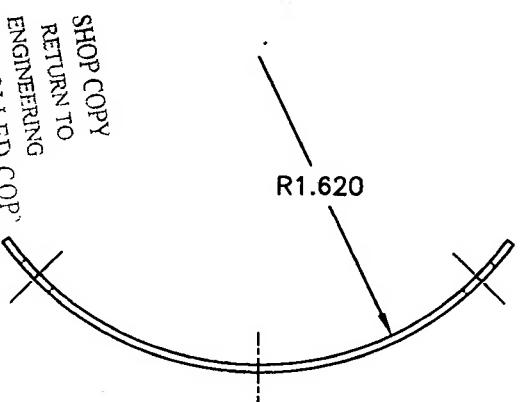
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 1 OF 7 SCALE 1:1

**DETAIL A****DETAIL B****SECTION C-C**

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